

Work Order ID: **77271-2**

Wednesday, November 30, 2011 3:27:41 PM

77271

Page 1

Item ID: **D3687-1**

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: MOUNT

Stop ***NS2***

Start Date: 11/30/2011 Start Qty: 6.00

6

Cust Item ID:

Required Date: 12/23/2011 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan: *mf*

Date: *11-11-30*

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3687	Rev C								

100

0.00

100

Outsource1

Memo

0.00

Outsource process - Heat Treat

Send M174B3937X4750 For heat treating
to CONDITION H-900(to become M174PHH900B3937X4750)
FTU IN EXCESS OF 190 KSI
FTU IN EXCESS OF 170 KSI

CERTIFICATE IS REQUIRED

*material already
to H900*

CL 11/12/06

105

0.00

105

Outsource5

Memo

0.00

Outsource process - Machining

Issue P/O: *15623*
Machine as per Dwg D3687
Possible Supplier: Globus Precision
Conformity sheet required

CL 11/12/06 (6)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 77271

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Page 2

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Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: MOUNT

Stop ***NS2***

Start Date: 11/30/2011 Start Qty: 6.00

6

Cust Item ID:

Required Date: 12/23/2011 Req'd Qty: 6.00

6

Customer:

Reference:

Run Start ***NR1***

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop ***NR2***

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

110

Receive & Inspect for Damage & Mat'l Certs

0.00

110

Packaging

Memo

0.00

Packaging

Ensure certificate of conformity is attached

6/2/7 (5)

120

QC6- Inspect dimensions to drawing

0.00

120

QC

Memo

0.00

Quality Control

INSPECT HOLE ALIGHMENT USING DT9707 JIG

8/26/09

(5)

124

0.00

124

Purchasing

Memo

0.00

Purchasing

Issue P/O FOR LIQUID PENETRATION

P/O #: 16169

Certificate of conformity is required

C2 12/02/10 5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 77271

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77271

Page 3

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Accept

N900040100

Setup

Start

NS1

Revision ID:

Item Name: MOUNT

Stop

NS2

Start Date: 11/30/2011 Start Qty: 6.00

6

Cust Item ID:

Required Date: 12/23/2011 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

125

Receive & Inspect for Damage & Mat'l Certs

0.00

125

Packaging

Memo

0.00

Packaging

ENSURE NDT RESULT IS ATTACH

126

QC5- Inspect part completeness to step on W/O

0.00

126

QC

Memo

0.00

Quality Control

127

QC6- Inspect dimensions to drawing

0.00

127

QC

Memo

0.00

Quality Control

DIMENSIONAL CHECK,
ENSURE THAT BOLT HOLES ARE CORRECT SIZE

isD

OW

isD

Per 12/10

8/12/10

(45)

Done @ 12/10

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Work Order ID 77271

77271

Page 4

Wednesday, November 30, 2011 3:27:41 PM

Item ID: D3687-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: MOUNT
Start Date: 11/30/2011 Start Qty: 6.00 ***6*** Cust Item ID:
Required Date: 12/23/2011 Req'd Qty: 6.00 ***6*** Customer:
Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: <u>GA</u>	0.00							
130									
Packaging	Memo	0.00							
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

12/2/13 sf (S)

12/2/13 J

12-02-13
(S)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Wednesday, November 30, 2011 3:27:40 P

Page 1

Work Order ID: 77271

Parent Item: D3687-1

Parent Item Name: MOUNT

Start Date: 11/30/2011

Required Date: 12/23/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A New Issue 08-01-15 JLM Verified By:EC
 IPP Rev:B Added Contion H-900 JLM Verified By:DD IPP REV C: ADDED QC6
 10.09.09 JLM VERIFIED BY DD
 IPP REV D:ADDED DT9707 INSPECTION JIG 11-01-05 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M174PH- H900B3.937X4.750 17-4SS Bar H900-3.937x4.750		Purchased	No			100	f	17.0000	0.53333	1.99998			
<div> <div>Location</div> <div>Loc Qty</div> <div>Loc Code</div> </div>													
				MAT005		17							
				112374		17							
D3687-1P MOUNT		Purchased	No			105	Each	0.0000	1	6			

C21112106

1.999

12/2/11 (5)

Dart Aerospace Ltd

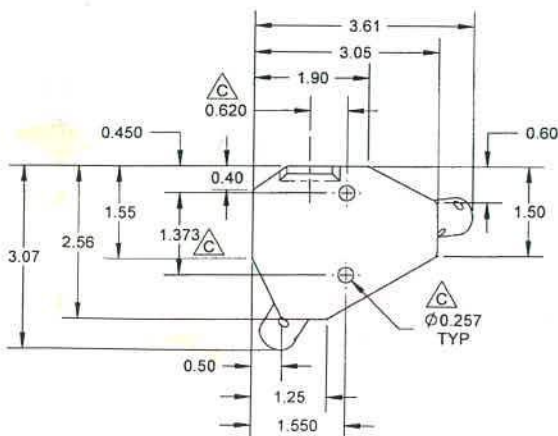
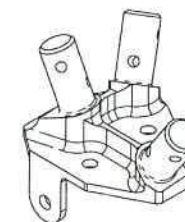
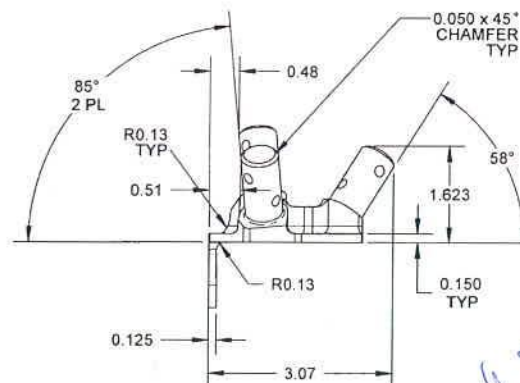
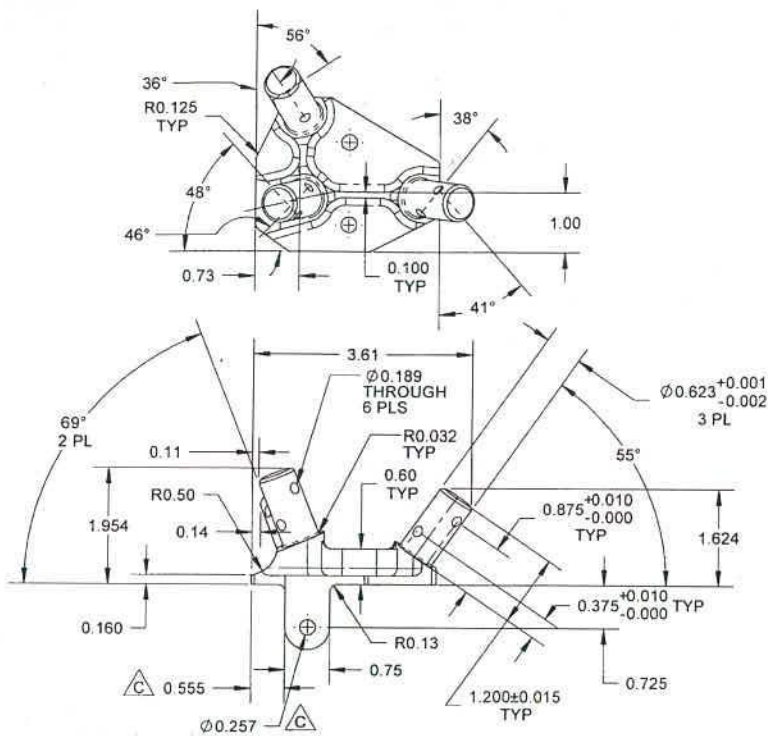
W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries



D3687-1 MOUNT

- NOTES:
- 1) MATERIAL: 17-4PH SS BAR PER AMS 5643, H-900 CONDITION
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.81 lb
 - 8) LPI PER QSI 038 4.1.1 (ASTM E1417 LEVEL 2)

RELEASED
2009-09-22

C	0.555 WAS 0.50 (ZN B8-1); 1.373 WAS 1.375 (ZN A8-1, A8-2); ADD 0.620 (ZN B7-1) PER NCR09-084; UPDATE NOTE 8 TO REF QSI (ZN A8-1, B3-2); 0.257 WAS 0.250 (ZN A6-1, B7-2)	RF	09.08.26
B	CHANGE TO 17-4PH H-900 (ZN A6-1 & B3-2); R0.032 WAS R0.015 (ZN C7-1 & C7-2); REFORMATTED TO CURRENT DWG STANDARDS	RF	08.11.24
A	NEW ISSUE	RF	08.03.12
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	GP	DRAWING NO.	REV: C
MFG. APPR.	GP	D3687	SHEET 1 OF 2
APPROVED	GP	TITLE	SCALE
DE APPR.	GP	MOUNT	NTS
DATE	09.08.26	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

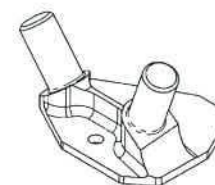
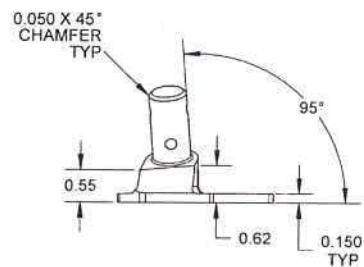
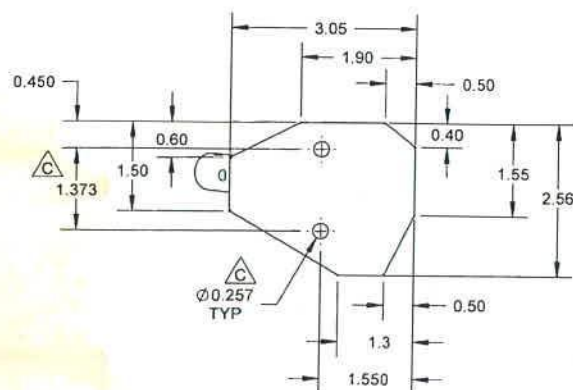
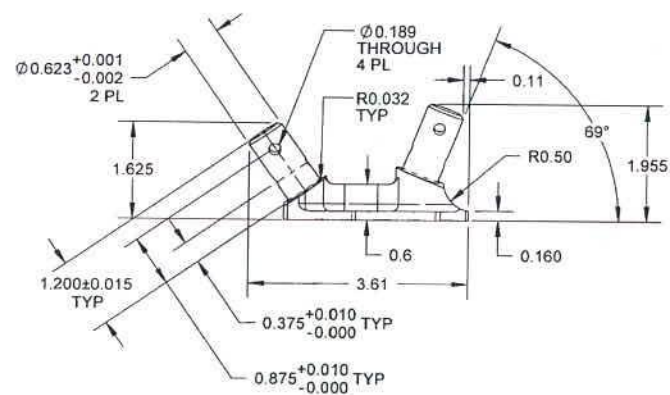
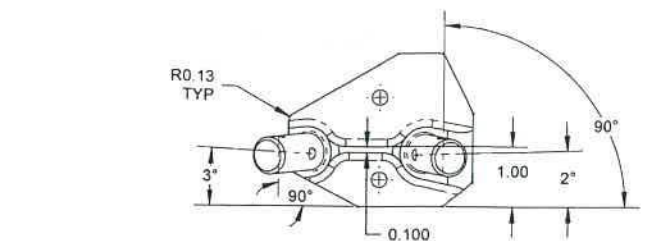
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



- NOTES:
- 1) MATERIAL: 17-4PH SS BAR PER AMS 5643, H-900 CONDITION
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.64 lb
 - 8) LPI PER QSI 038 4.1.1 (ASTM E1417 LEVEL 2)

D3687-3 MOUNT

RELEASED
2009-09-22

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	GP	DRAWING NO.	REV. C
MFG. APPR.	GP	D3687	SHEET 2 OF 2
APPROVED	GP	TITLE	SCALE
DE APPR.	GP	MOUNT	NTS
DATE	09.08.26	COPYRIGHT © 2008 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY FORM OR BY ANY MEANS WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO15623

Purchase Order Date 12/06/11

PO Print Date 12/08/11

Page Number 1 of 1

Order From : VC-GLO001

ARCHER PRECISION INC.
36 COLONNADE RD. N.
NEPEAN, ON K2E 7J6
CA

Contact Name		Buyer	Chantal Lavoie
Vendor Phone	613 226 1579	Requisition Nbr	
Vendor Fax	613 226 1719	Tax Resale Nbr	10127-2607
Vendor Account Nbr		Terms	Net 30
		Currency	CAD
		FOB	Destination-Collect

To : DART AEROSPACE LTD 1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
D3687-1P		MOUNT	1/17/12 Yes	6.00 Each	Yours ppd	\$400.0000	\$2,400.00
Special Inst:		MACHINE AS PER DWG D3687 REV. C B77271					

PO Total: \$2,400.00

Change Nbr: 2

Change Date: 12/08/11

No substitution or deviation without
consent.
Certificate of Conformance or Material
Certification required when applicable



1393 Major Road
Orleans, ON
K1E 1H3

Phone # 613-899-2405

Packing Slip

Date	Invoice #
2/6/2012	42

Ship To
Main Finished Goods Location Dart Aerospace 1270 Aberdeen Street Hawksbury, Ontario K6A 1K7

P.O. No.	Ship	Via	FOB	Project
15623	2/6/2012	Pick-Up	Archer	

Qty	Item Code	Description
5	Sales	D3687-1P Mount HST (ON) on sales



1393 Major Road
Orleans, Ontario
K1E 1H3

Telephone (613) 899-2405
Fax (613) 226-1719

Certificate of Compliance

To:
Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury Ont.
K6A 1K7

8/2/09

Po Number	Part Number	Quantities
15623	D3687-1P	5

It is hereby certified that all articles mentioned above are in conformance with the requirements, specification and drawings as listed on customer purchase order number, 15625 issued by Dart Aerospace Inc.

A handwritten signature in black ink, appearing to read 'Alex Mazerolle', written over a horizontal line.

Alex Mazerolle
President
Archer Precision Inc.
1393 Major Road,
Orleans Ontario
K1E 1H3



LIQUID PENETRANT TEST REPORT

P- 12177

CLIENT DART Aerospace DATE FEB 10-2012 PAGE 1 OF 1
ATTENTION LINDA/CHANTEL ACUREN JOB NO. 188-12-C0031 TIME AM ☒ PM ☐
ADDRESS 1270 ABERDEEN ST. PO/WO NO. N/A
HAWKESBURY ON. WORK LOCATION SAME
PROJECT F.P.I. on CROSS TUBES AND MACHINED PARTS ACCEPTANCE STD. ASTM 147/051-038 REV./DATE 2005
ITEM(S) EXAMINED (4) CROSS TUBES (5) MOUNTS

JOB DESCRIPTION WET FLOUORESCENT LIQUID PENETRANT INSPECTION WAS PROCEDURE NO. LT0002 REV./DATE 2008 TECHNIQUE NO. LT0002 REV./DATE 2008

PART NO. SFE RESULTS MATERIAL ALUMINUM THICKNESS VARIABLE
SCOPE WET FLOUORESCENT LIQUID PENETRANT INSPECTION WAS
CARRIED OUT ON 100% EXTERNAL SURFACE.

TEST DETAILS
METHOD ☒ FLUORESCENT ☐ VISIBLE ☒ WATER WASH ☐ SOLVENT REMOVABLE ☐ POST EMULSIFIED
FAMILY BRAND MACNAFLUX BLACK LIGHT S/N 16959 ☐ OUTPUT > 1000 μ W/cm² ☐ AMBIENT < 2 fc
PENETRANT 2-LO7 MINIMUM DWELL TIME 45 MIN. LIGHTING EQUIP. ☐ FLASHLIGHT ☐ TROUBLELIGHT ☐ OUTPUT > 100 fc @ SURFACE
PENETRANT REMOVER H2O MINIMUM DRY TIME >10 MIN. OTHER LABINO
DEVELOPER SKD 52 MINIMUM DWELL TIME 10 MIN. LIGHT METER S/N 1098866 CAL DUE DATE JUL 27 2012
DEVELOPER TYPE ☒ NON AQUEOUS ☐ AQUEOUS ☐ DRY

TEST SURFACE
SURFACE CONDITION ☐ AS GROUND ☐ AS WELDED ☒ MACHINED ☐ SHOT BLASTED ☒ CLEAN BARE METAL
SURFACE TEMPERATURE ☐ < -4°C/ 20°F ☐ -4°C/ 20°F TO 10°C/50°F ☒ 10°C/50°F TO 52°C/125°F ☐ > 52°C/125°F

RESULTS- ☒ METRIC ☐ IMPERIAL

51 MOUNTS - W.O. 77271 ✓
1 CrossTube W.O. 76449 ✓
1 CrossTube W.O. 76448 ✓
1 CrossTube W.O. 79678 ✓
1 CrossTube W.O. 79677 ✓
S. 1210210

Scope of Services
The agreement of Acuren Group Inc. to perform services extends only to those services provided for in writing. Under no circumstances shall such services extend beyond the performance of the requested services. It is expressly understood that all descriptions, comments and expressions of opinion reflect the opinions or observations of Acuren Group Inc. based on information and assumptions supplied by the owner/operator and are not intended nor can they be construed as representations or warranties. Acuren Group Inc. is not assuming any responsibilities of the owner/operator and the owner/operator retains complete responsibility for the engineering, manufacture, repair and use decisions as a result of the data or other information provided by Acuren Group Inc. In no event shall Acuren Group Inc.'s liability in respect of the services referred to herein exceed the amount paid for such services.

Standard of Care
In performing the services provided, Acuren Group Inc. uses the degree, care and skill ordinarily exercised under similar circumstances by others performing such services in the same or similar locality. No other warranty, expressed or implied, is made or intended by Acuren Group Inc.

SIGNATURES

CLIENT REPRESENTATIVE Andrew Sheldon PRINT ASheldon SIGNATURE DTR # E63807
TECHNICIAN (SIGNATURE): Mike I. Husker REPORT REVIEWED BY: NAME INITIALS
NAME (PRINT): Mike I. Husker 1st TECHNICIAN 2nd TECHNICIAN
CGSB LEVEL 1 SNT LEVEL 6006 CGSB LEVEL 1 SNT LEVEL 6006
CGSB REG. NO. 6006 CGSB REG. NO. 6006